

Work Order ID 63317

Wednesday, October 27, 2010 2:59:21 PM



Page 1

Item ID: D3670-4-200

Accept



Setup Start



Revision ID:

Stop



Item Name: SPACER

Start Date: 10/27/2010 Start Qty: 30.00



Cust Item ID:

Required Date: 11/11/2010 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10/10/27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3670	Rev A								
100	Hardinge CNC LATHE SMALL	0.00							
	Hardinge								
Hardinge CNC Lathe Small	Memo	0.00							
	1-TURN AS PER FOLIO FA711 & DWG D3670 □ FOLIO REV: <i>11</i>								
	DWG REV: <i>11</i>								
	2-DEBURR AS REQUIRED								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							
120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							

10-11-1

30

10-11-1

30

M.A 10/11/01

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Stop

Item Name: SPACER

Start Date: 10/27/2010 Start Qty: 30.00

Cust Item ID:

Required Date: 11/11/2010 Req'd Qty: 30.00

Customer:



Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
Packaging	Memo	0.00							
Packaging	***STOCK IN SKIDTUBE CELL***								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

rdh/asp 300

che 10/11/02

MF

10-11-01

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Wednesday, October 27, 2010 2:59:26 PM

Page 1

Work Order ID: 63317



Parent Item: D3670-4-200



Parent Item Name: SPACER

Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 30.00

Required Qty: 30.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6T0.3125W.05
8

Purchased

No

f

96.4337

0.36

10.80540



R 10.19.1

ALUM TUBE .3125 x .058w

Location

Loc Qty

Loc Code

MAT

19.43368421

14559

19.4336842

MAT013

77

115894

77

10.5

4.2 126

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

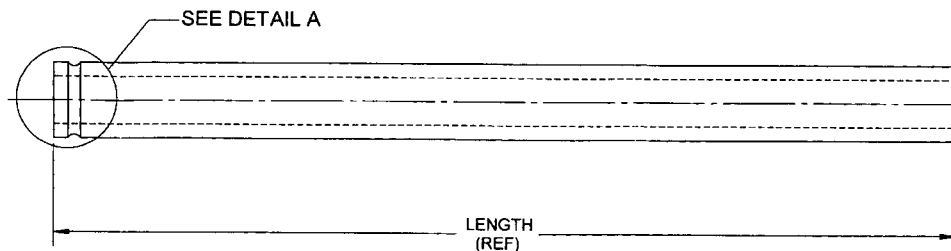
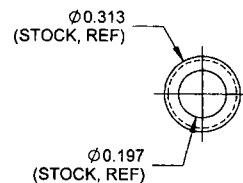
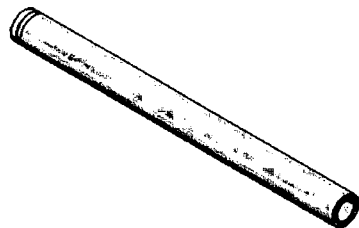
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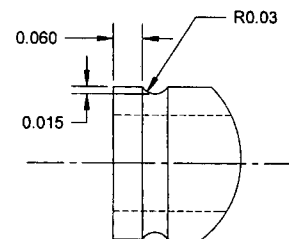
NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43317

BS 10-10-27



DETAIL A
(SCALE 4 : 1)

SPECIFICATION: D3670-XXXX SPACER
LENGTH

WHERE XXXX IS LENGTH IN INCHES
EG: 3.750" LONG SPACER: D3670-3750

RELEASED
07.11.06

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

A	NEW ISSUE	DC	07.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DF		
CHECKED	h	DRAWING NO.	REV. A
MFG. APPR.	Ego	D3670	SHEET 1 OF 1
APPROVED	MI	TITLE	SCALE
DE APPR.		SPACER	2:1
DATE	07.10.19	<small>COPY RIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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